



**PRODUCT MANUAL FOR
COMPOSITE CEMENT
ACCORDING TO IS 16415 : 2015**

This Product Manual shall be used as reference material by all Regional/Branch Offices & licensees to ensure coherence of practice and transparency in operation of certification under Scheme-I of Bureau of Indian Standards (Conformity Assessment) Regulations, 2018 for various products. The document may also be used by prospective applicants desirous of obtaining BIS certification licence/certificate.

| | | | |
|----|--|---|--|
| 1. | Product | : | IS 16415 : 2015 |
| | Title | : | COMPOSITE CEMENT |
| | No. of Amendments | : | Nil |
| 2. | Sampling Guidelines: | | |
| a) | Raw material | : | a) Granulated slag – IS 12089 b) Fly ash – IS 3812 (Part 1) c) Portland Cement Clinker – IS 16353 d) Portland Cement - IS 269 |
| b) | Grouping guidelines | : | Not Applicable |
| c) | Sample Size | : | Composite Cement – 8 kg for physical test 1 kg for chemical test |
| 3. | List of Test Equipment | : | Please refer ANNEX – A |
| 4. | Scheme of Inspection and Testing | : | Please refer ANNEX – B |
| 5. | Possible tests in a day : | | |
| | (i) Insoluble Residue (ii) Loss of ignition (iii) Fineness (iv) Setting time (v) Magnesia (vi) Sulphide sulphur | | |
| 6. | Scope of the Licence : | | |
| | “Licence is granted to use Standard Mark on Composite Cement as per IS 16415 : 2015”. | | |
| | Any other aspect required as per the Standard | | Transverse strength test is optional test as per agreement between purchaser and manufacturer. |

ANNEX A**List of Test Equipment***Major test equipment required to test as per the Indian Standard*

| SI No. | Tests used in with Clause Reference | Test equipment |
|---------------|---|--|
| 1 | Fineness Clause 7 Table 3 | Blaine's apparatus variable flow type with permeability cell and perforated metal disc |
| | | Stop watch with start-stop mechanism |
| | | Mercury for calibration |
| | | Balance, Standard weights |
| | | Standard Cement |
| | | Manometer liquid (di-butyl phthalate or light mineral oil.) |
| | | Mercury of reagent grade or better, Pyknometer |
| | | Circular discs of filter paper of medium porosity (mean pore diameter 7 μ). |
| | | Le-Chatelier's flask |
| | | Constant temperature water bath to maintain temp. within ± 0.1 °C |
| 2 | Soundness by Autoclave Clause 7 Table 3 | Auto clamp machine with thermostatic control to maintain pressure of 2.1 MPa for 3 hrs, pressure to be attained within 1-1 ¼ hrs; |
| | | L-Shape thermometer LC 1 °C |
| | | Pressure gauge 0-42 kg/cm ² LC = 0.4 kg/cm ² |
| | | Humidity chamber with temperature & RH control 27 \pm 2 °C, RH 90 to 100 % |
| | | Standard bar 308 mm, max |
| | | Bar moulds 25 x 25 x 282 mm |
| | | Length comparator with dial gauge |
| 3 | Soundness by Le-chatelier Method Clause 7 Table 3 | Le-Chatelier's water bath preferably with thermostatic control raising temperature from 27 \pm 2 °C to boiling in 27 \pm 3 minutes |
| | | Le-Chatelier's moulds with weights and cover glasses minimum 8 nos. |
| | | Humidity chamber with temperature & RH control 27 \pm 2 °C, RH 90 to 100 % |
| | | Steel scale 12" (304.8 mm) |

| | | |
|----|---|--|
| 4 | Setting time Clause 7 Table 3 | Vicat apparatus |
| | | Needle for Consistency, IST& FST testing |
| | | Moulds |
| | | Stop Watch |
| | | Balance – 1000 g \pm 0.1 g and Standard Weights 1 mg to 500 gm |
| | | Gauging trowel of weight 210 \pm 10 g |
| 5 | Compressive Strength Clause 7 Table 3 | Vibration machine with timer & cube mould fitting assembly 12000 \pm 400 vibration per min. |
| | | Compressive Strength machine |
| | | Poking Rod , Petroleum Jelly |
| | | Proving ring with all accessories suitable for calibration of CST machine |
| | | Tachometer |
| | | Cube Moulds 70.6 \times 70.6 mm, Poking rod |
| | | Gauging trowel (210 \pm 10 g) gauging plate, stainless steel(non-perforated) |
| | | Standard sand (as per IS 650) |
| | | Curing tank of appropriate size with water circulation arrangement |
| | | Graduated glass cylinders 150 to 200 ml |
| | | Humidity chamber with temperature & RH Control 27 \pm 2° C, RH 90 to 100 % |
| 6 | Transverse Strength Test Clause 7, Table 3 | Moulds |
| | | Planetary Mixer, Standard Sand |
| | | Jolting Apparatus, Scraper, Demolding device as per IS 4031 (Part 8) |
| 7 | IS 16415 : 2015 | General equipments for Cement testing |
| a) | To control humidity & temperature in lab | 1. Humidity chamber with temperature & RH control 27 \pm 2°C, RH 90 to 100 % 2. Suitable arrangement to demonstrate maintenance of temp. of 27 \pm 2 ° C & RH 65 \pm 5% constantly |
| b) | For cement Sampling | Mixing trays –adequate size including trays of 24 partitions for keeping hourly samples |
| c) | To control the residue of cement | Sieves of size (300, 212, 150, 90, 75 & 45 μ) |
| d) | To measure temperature | Thermometers |
| e) | Lab ball mill (motorized) | To grind the clinker, slag & gypsum sample in lab ball mill for testing |

| | | |
|----|---|--|
| f) | To weigh the material | 1. Platform type balance 2. Electrical balance 3 Weight box with weights (1 mg - 500 g) |
| 8 | General test equipments for chemical testing Clause 6 , Table 2 of IS 16415 : 2015 | |
| | | Muffle Furnace with thermostatic control, Range 0 – 1200° C |
| | | Oven with thermostatic control 0-300° C |
| | | Heater and hot plate |
| | | Distillation Assembly |
| | | Crucible: Platinum or Porcelain / silica |
| | | Filter paper (No- 1, 40, 41, 42) |
| | | Desiccators with cover & Desiccant |
| | | Water bath |
| | | pH meter/paper |
| | | Glassware - volumetric flask -0-250 ml, beaker 0-250 ml, measuring cylinder 0-50,100,500, 1000 ml, burette 0-25/50 ml, conical flasks- 0-250 ml, pipette 0-5,10, 25, 50 ml |
| | | All chemicals required for complete chemical analysis of cement |
| | | Tongs including platinum tipped tong |
| | | Wire gauge with asbestos sheet at the middle |
| | | Washing bottle |
| | | Mortar mixer- 4.75 l Glass thermometer |
| | | All required chemicals as per IS 4032 for Composite cement and Portland cement clinker, fly ash and granulated slag testing. |
| | | Steam bath |
| | | Hot plate |
| | | Gas generating flask (Sulphide Sulphur apparatus) |
| | | Micro burette |
| | | Flame photometer |
| 9 | Granulated Slag Clause 4.1 and IS 12089 | a) Glass Content - Optical microscope min 100 X - Bromoform b) Chemical requirement - As per IS 4032 |

| | | |
|----|---|---|
| 10 | Fly ash testing [clause 4.2 of IS 16415 : 2015 and IS 3812 (Part 1) : 2013] | |
| | Chemical Test | Chemicals and glassware as per IS 1727 and IS 4032, Flame photometer |
| | Loss on ignition | Muffle furnace Crucible (Silica /Platinum) Weighing balance |
| | Fineness | Blain Apparatus Permeability cell , Disk, Plunger, Filler paper U-Tube manometer with manometer liquid Stop watch with Stop-Start mechanism Standard sample Mercury for calibration Pycnometer, Thermometer |
| | Residual on 45 μ sieve | 45 μ sieve Balance Oven |
| | Soundness by autoclave | Same as cement above |
| | Lime reactivity | 50 mm cubes moulds Planetary mixer , paddle, mixing bowl, scrapper Flow table and Accessories Tamping rod Trowel etc |
| | Compressive strength | 50 mm cube moulds Planetary mixer , paddle, mixing bowl, scrapper Flow table and Accessories Tamping rod Trowel etc |
| | Drying shrinkage | Balance with weights Trowel Length comparator Flow table and Accessories Beam mould- 25 x 25 x 282 mm Humidity and Temperature control cabinet. |

ANNEX B**SCHEME OF INSPECTION AND TESTING**

1. LABORATORY - A laboratory shall be maintained which shall be suitably equipped (as per the requirement given in column 2 of Table 1) and staffed, where different tests given in the specification shall be carried out in accordance with the methods given in the specification.

1.1 The manufacturer shall prepare a calibration plan for the test equipments. The following equipments shall be calibrated at a frequency shown against each and records kept.

| Sl. No. | TEST EQUIPMENT | FREQUENCY OF CALIBRATION |
|---------|--|---|
| 1. | Blaine's apparatus | Daily with licensee's own Standard cement sample and monthly with standard cement samples supplied by NCCBM. |
| 2. | Compressive strength Testing machine | Once in a month with Licensee's own Proving Ring and the Proving Ring shall be Calibrated once in two years from a NPL/NABL Accredited Calibrating body or NPL or NPL accredited Proving Ring manufacturer. |
| 3. | Autoclave pressure gauge | Once in a month by licensee's own dead weight pressure gauge tester OR once in six months from accredited calibrating body or NPL/NABL accredited manufacturer of such gauges. |
| 4. | Vibration machine | Once in a month by licensee's own Tachometer. The tachometer shall be calibrated once in a year from NPL/NABL accredited outside agency. |
| 5. | Dead weight pressure gauge Tester (if available) | Once in four years from NABL accredited Tester (if available) Lab or OEM (original Equipment manufacturer) having NPL/NABL accredited calibrator. |

2. TEST RECORDS – The manufacturer shall maintain test records in various formats, Form 1 to Form 20 for the tests carried out to establish conformity.

3. LABELLING AND MARKING – Labeling and marking shall be as given below:

3.1 STANDARD MARK - The Standard Mark, as specified by BIS, shall be printed or stenciled on each bag or drum of Composite Cement or on the label applied to it, provided the material in each bag or package to which the mark thus applied conforms to the specification. The size of the Standard Mark shall be either **160 x 120** mm or **80 x 60** mm for packing in quantity of 50 kg and above. For other packing of lower quantity, a photographic reduction is permitted.

3.2 MARKING - As per the requirements of IS 16415 : 2015.

3.2.1 In addition to above, following marking shall also be marked:

a) Name of original manufacturer of cement with BIS licence number in case of repacking unit.

b) Any other marking required under provisions of Legal Metrology Act, 2009 and Legal Metrology (Packaged Commodities) Rules, 2011 framed thereunder.

3.2.2 All the information including BIS Standard Mark except Manufacturers Registered Trade Mark shall be applied on each bag in **BLUE COLOUR**.

3.2.3 Marking of variable parameters on cement bags which are changing with production schedule and done online (such as Date of manufacturing/Week number/Batch number, MRP, Percentage of addition of Pozzolana) is permitted in BLACK COLOUR. However, all such marking shall be conspicuous.

Note :

1. For each calendar year, the first week shall be counted as 7 days from 1st of January and subsequent weeks numbered serially accordingly. The bags shall be marked as W 01/MM/YY..... W 51/MM/YY..... etc.
2. Label mentioned at 3.1 and 3.2 above shall be attached to the seal of the container. The seal shall be of such a design that it shall automatically get destroyed on opening.
3. The colour of the bag and background colours should be in contrast to the colour of the Standard Mark and the details so that the markings are conspicuous.

4. CONTROL UNIT –

4.1 For manufacturing units of Composite Cement: The tests, as indicated in Table 1 attached and at the levels of control specified therein, shall be carried out on the whole production of the factory which is covered by this scheme and appropriate records maintained in accordance with clause 2 above.

4.2 For packing of Composite Cement at bulk cement terminal: The tests, as indicated in Table 2 attached and at the levels of control specified therein, shall be carried out on the whole packing of Composite Cement and appropriate records maintained in accordance with clause 2 above.

4.2.1 For bulk packing units as per clause 4.2, all cement of one consignment received shall constitute one batch.

4.2.2 Batch mixing may be permitted for packing units, which are extended packing terminals of the same cement manufacturer (licensee) subject to packing units obtaining test certificates from the manufacturer and keeping proper records. If the cement is received from different units of the same manufacturer (different licensees) batch mixing of cement is not permitted. The Batch integrity shall be ensured at all stages of packing and the packer shall maintain appropriate controls and checks to ensure that there is no chance of mix up of different batches. Adequate care shall be taken to avoid spoilage during handling, packing and storage.

4.2.3 If bulk packing unit is instructed by BIS for suspension of licence due to the failure of the samples, such instruction will automatically apply to the original manufacturer of the cement, as per relevant suspension of licence guidelines. An undertaking to this effect shall be obtained from the bulk packers and the original cement manufacturer.

4.2.4 Test Certificate of each original batch of cement shall be obtained from the supplier and test results recorded. On the basis of tests and inspection, the decision regarding conformity or otherwise of the consignment/batch to a given requirement shall be taken.

4.3 WEIGHMENT – One filled bag from each nozzle shall be taken at random twice in each shift of operation and weight checked in case of electronic packers with recorders. In all other cases one filled bag from each nozzle shall be checked once in two hours. The records shall be maintained in Form 1. The bag shall be so chosen for weighment such that bags from each nozzle are taken for weighment. The weighing and packing machines shall be adjusted as and when necessary in such a way that net quantity of each bag shall be in accordance with the tolerances given in Annex B and clause 10.1.1 of IS 16415: 2015. Such adjustments for each nozzle shall be recorded in Form 1 under remarks column.

4.3.1 For packing of Composite Cement in bulk cement terminal weighment of hourly check of mass of drums also shall be done in addition to weighment of bags mentioned in para 4.3 above. The records of weighments shall be maintained in Forms 12 and 14.

4.4 RAW MATERIALS

4.4.1 Routine analysis of various raw materials used in the manufacture of Composite Cement shall be made at intervals of a month or whenever there is a change in the source/mine area stratification whichever is earlier and appropriate records of the analysis and of the Physical composition of the mixtures shall be maintained in Form 2. This analysis is not applicable for Packing Units of Composite Cement at bulk cement terminal.

4.5 HOMOGENEITY - Homogeneity of the mixture in a consignment shall be ensured within the stipulated percent of fly ash and slag addition. Percentage of Fly ash and Granulated Slag addition shall be declared every time and marked on the bags/package.

4.6. PACKING - The Cement shall be packed in bags as specified in clause 10 of IS 16415 : 2015. A test certificate either from the manufacturer or from any recognized testing laboratory shall be received along with each consignment of bags. Alternatively the samples of bags from each consignment shall be tested by the cement manufacturer either in his own laboratory or any other BIS recognized laboratory before they are used for packing cement. No testing would be necessary if the bags carry BIS Certification Mark. The bag shall be in good condition at the time of packing.

5. LEVELS OF CONTROL - The tests as indicated in column 1 of Table 1 and the levels of control in column 3 of Table 1, shall be carried out on the whole production of the factory which is covered by this plan and appropriate records maintained in accordance with clause 2 above.

5.1. PRODUCTION DATA - The licensee shall send to BIS a statement of quantity produced, marked and exported by him and the value thereof at the end of each quarter of the operative period as per the enclosed proforma and shall also submit these details to BIS at the end of the operative year duly authenticated by a Chartered Accountant.

6. REJECTIONS – Disposal of non-conforming product shall be done in such a way so as to ensure that there is no violation of provisions of BIS Act, 2016.

Table 1 – Levels of Control (Grinding/Packing Unit)

| (1) | | | | (2) | (3) | | | |
|------------------|--|----------------------------------|------------------------------|--|-------------------------------|--|-------------------------|--------|
| TEST DETAILS | | | | Test equipment requirement R: required (or) S: Sub-contracting permitted | RECOMMENDED LEVELS OF CONTROL | | | |
| Clause | Requirement | Test Methods Clause Reference | | | Number of sample | Frequency | | Remark |
| | | | | | | Cement Grinding/Blending | Cement Packing | |
| 4.1 | Granulated Slag | 4.1 | IS 16415 IS 12089 | S | One | One sample shall be tested from each supplier once in a month. No further testing required if accompanied with test certificate or ISI marked. | | |
| 4.2 | Fly ash | 4.2 | IS 16415 IS 3812 (Part 1) | R | One | One sample shall be tested from each supplier once in a week as per IS 3812 (Part 1). No further testing required if accompanied with test certificate or ISI marked. | | |
| 4.3 | Portland Cement Clinker | 4.3 | IS 16415 IS 16353 | R | One | Daily composite sample shall be tested for complete requirement as per IS 16353. No further testing required if accompanied with test certificate or ISI marked. | | |
| 4.4 | Ordinary Portland Cement | 4.4 | IS 16415 IS 269 | - | - | OPC shall be ISI marked and shall be accompanied with manufacturer certificate. If OPC is produced in the same factory, records as per relevant SIT shall be maintained. | | |
| 6 Table 2 | Chemical Requirement | | | | | | | |
| i) | Insoluble residue | 6 | IS 16415 IS 4032 | R | One | Daily Composite sample | Weekly composite sample | - |
| ii) | Magnesia | 6 | IS 16415 IS 4032 | R | One | Daily Composite sample | Weekly composite sample | - |
| iii) | Total Sulphur content calculated as sulphuric anhydride (SO ₃) | 6 | IS 16415 IS 4032 | R | One | Daily Composite sample | Weekly composite sample | - |

| | | | | | | | | |
|------------------|--|---|------------------------------|---|-----|---|-------------------------|---|
| iv) | Sulphide Sulphur (S) | 6 | IS 16415 IS 4032 | R | One | Daily Composite sample | Weekly composite sample | - |
| v) | Loss on ignition | 6 | IS 16415 IS 4032 | R | One | Daily Composite sample | Weekly composite sample | - |
| vi) | Chloride Content | 6 | IS 16415 IS 4032 | R | One | - | Weekly composite sample | This test shall also be carried out whenever there is any change in source of any raw material. |
| vii) | Alkali Content | 6 | - | S | One | - | - | Pl see note under Table 2 of IS 16415 : 2015. |
| 7 Table 3 | Physical Requirements | | | | | | | |
| i) | Fineness | 7 | IS 16415 IS 4031 (Part 2) | R | One | 1. Every alternate hourly from each mill separately. 2. Daily Composite sample | Daily Composite sample | - |
| ii) | Soundness (Le-Chatelier method and Autoclave method) | 7 | IS 16415 IS 4031(Part 3) | R | One | Daily Composite sample | Daily Composite sample | - |
| iii) | Setting Time | 7 | IS 16415 IS 4031 (Part 5) | R | One | One sample per shift (Composite sample) | Daily Composite sample | - |
| iv) | Compressive strength | 7 | IS 16415 IS 4031 (Part 6) | R | One | Daily Composite sample | Daily Composite sample | - |

| | | | | | | | | |
|-----|--------------------------------|---|------------------------------|---|-----|-------------------------|-------------------------|---|
| v) | Drying shrinkage | 7 | IS 16415 IS 4031(Part 10) | R | One | - | Weekly composite sample | - |
| vi) | Transverse strength (Optional) | 7 | IS 16415 IS 4031(Part 8) | S | One | Weekly composite sample | Weekly composite sample | - |

NOTES –

- Composite sample shall be made out of hourly samples for the required period (PI see IS 3535 Methods of sampling hydraulic cements).
If cement is manufactured using same proportion of raw materials from more than one cement mill, sample from each mill shall be tested for fineness as per the above table. For all other parameters composite samples from all the mills shall be tested.
If cement is manufactured using different proportion of raw materials from more than one cement mill, sample from each mill shall be tested for all requirements as per the above table.
- For manufacturing units where there is no packing silo and cement is packed directly from cement grinding, the frequency of tests specified for cement grinding stage would apply for the various tests to be carried out on samples taken from cement mill spouts along with weekly chloride content test.
- Material proportion of Portland Cement Clinker/Portland Cement, Fly ash and Granulated slag in manufacturing of Composite Cement shall comply with provisions of Clause 5.1 (Table 1) of IS 16415: 2015.
- Sub-contracting is permitted to a laboratory recognized by the Bureau or Government laboratories empaneled by the Bureau.
- The control unit and levels of control as decided by the Bureau are obligatory to which the licensee shall comply with.

Table 2 Level of Control (Bulk Packing Unit)

| (1) | | | | (2) | (3) | | |
|------------------|----------------------|----------------------------------|-----------------------------|--|-------------------------------|------------|---|
| TEST DETAILS | | | | Test equipment requirement R: required (or) S: Sub-contracting permitted | RECOMMENDED LEVELS OF CONTROL | | |
| Clause | Requirement | Test Methods Clause Reference | | | Number of samples | Frequency | Remarks |
| 6, Table 2 (i) | Insoluble Residue | 6 | IS 16415 IS 4032 | R | One | Each batch | To be tested in laboratory at bulk terminal packing unit. |
| 6, Table 2 (iv) | Sulphide Sulphur | 6 | IS 16415 IS 4032 | R | One | Each batch | |
| 6, Table 2 (v) | Loss on Ignition | 6 | IS 16415 IS 4032 | R | One | Each batch | |
| 7, Table 3 (i) | Fineness | 7 | IS 16415 IS 4031(Part 2) | S | One | Each batch | - |
| 7, Table 3 (ii) | Soundness | 7 | IS 16415 IS 4031(Part 3) | S | One | Each batch | |
| 7, Table 3 (iii) | Setting Time | 7 | IS 16415 IS 4031(Part 5) | S | One | Each batch | |
| 7, Table 3 (iv) | Compressive strength | 7 | IS 16415 IS 4031(Part 6) | S | One | Each batch | |

Note-1: Sub-contracting is permitted to a laboratory recognized by the Bureau or Government laboratories empaneled by the Bureau.

Note-2: The control unit and levels of control as decided by the Bureau are obligatory to which the licensee shall comply with.

Form No. 1

FORMAT FOR MAINTENANCE OF TEST RECORDS WEIGHMENT CONTROL AT PACKING STAGE

| Date | Shift | Time (Hourly) | No. of Bags | Net mass of bags from nozzles | | | | | | Remark. |
|------|-------|---------------|-------------|-------------------------------|--|--|--|--|--|---------|
| | | | | | | | | | | |

Form No. 2

RAW MATERIAL TESTING

| Date of receipt of material | Date of testing | Name of Material | Source of supply and consignment No. | Details of analysis for specified requirements |
|-----------------------------|-----------------|------------------|--------------------------------------|--|
| | | | | |

Form 3

PRODUCTION DATA

(POST GRINDING DETAILS OF PRODUCTION ACCEPTED AND REJECTED FOR STANDARD MARK)

| Shift | Quantity | Passed for Standard mark | Rejected | Remark |
|-------|----------|--------------------------|----------|--------|
| | | | | |

Form No. 4

CLINKER CHEMICAL COMPOSITION (DAILY COMPOSITE SAMPLE)

| Date of manufacture | Total loss on ignition | Insoluble residue | Alkali content as Na ₂ O @ | C ₃ S | C ₃ A | C ₃ S+C ₂ S | SO ₃ | MgO | Chloride | Free lime | LSF | Alumina factor | Sample Pass/Fail | Remarks |
|---------------------|------------------------|-------------------|---------------------------------------|------------------|------------------|-----------------------------------|-----------------|-----|----------|-----------|-----|----------------|------------------|---------|
| | | | | | | | | | | | | | | |

@ Alkali content test may be conducted as and when required by purchaser

Form No. 5

CLINKER GROUND WITH GYPSUM (DAILY COMPOSITE SAMPLE)

| Date of grinding | Fineness | Soundness | | Setting time | | Compressive strength | | | Sample Pass/Fail | Remark |
|------------------|----------|--------------|-----------|--------------|-------|----------------------|--------|---------|------------------|--------|
| | | Le-Chatelier | Autoclave | Initial | Final | 3 days | 7 days | 28 days | | |
| | | | | | | | | | | |

Form No. 6

Fly ash (One sample per week)

| Date | CHEMICAL | | | | | | | | PHYSICAL | | | | |
|------|--|------------------|-----------------|-----|----------------------------------|---------------------------------------|----------------|-----|----------|-----------------|---------------------------|------------------------|--|
| | SiO ₂ + Al ₂ O ₃ + Fe ₂ O ₃ | SiO ₂ | Reactive Silica | MgO | Total Sulphur as SO ₃ | Available alkali as Na ₂ O | Total Chloride | LOI | Fineness | Lime Reactivity | Comp. Strength at 28 Days | Soundness by autoclave | Particle retained on 45 μ sieve (Optional) |
| | | | | | | | | | | | | | |

Form No. 7

Granulated Slag (One sample per month)

| Date | CHEMICAL | | | | | | | PHYSICAL | | |
|------|----------|-----|------------------|--|--|---|---------------|----------|------------------|--|
| | MnO | MgO | Sulphide Sulphur | $\frac{\text{CaO} + \text{MgO} + \frac{1}{3}\text{Al}_2\text{O}_3}{\text{SiO}_2 + \frac{2}{3}\text{Al}_2\text{O}_3}$ | $\frac{\text{CaO} + \text{MgO} + \text{Al}_2\text{O}_3}{\text{SiO}_2}$ | $\frac{\text{CaO} + \text{CaS} + \frac{1}{2}\text{MgO} + \text{Al}_2\text{O}_3}{\text{SiO}_2 + \text{MnO}}$ | Glass content | IR | Moisture content | |
| | | | | | | | | | | |

Form 8

COMPOSITE CEMENT (GRINDING/ BLENDING) (Daily/Weekly Composite sample)

| Date of grinding | IR | MgO | Total Sulphur calculated as SO ₃ | Sulphide Sulphur | LOI | Chloride Content | Alkali content @ | Fineness | Soundness (Le-chatelier & Autoclave) | Setting Time Initial & Final | Compressive strength | Drying Shrinkage | Transverse Strength | Sample Pass/Fail | Action taken if sample fails |
|------------------|----|-----|---|------------------|-----|------------------|------------------|----------|--------------------------------------|------------------------------|----------------------|------------------|---------------------|------------------|------------------------------|
| | | | | | | | | | | | | | | | |

@ Alkali content test may be conducted as and when required by purchaser

Form No 9

COMPOSITE CEMENT GRINDING (For Alternate Hourly Sample)

| Date of grinding | Time | Fineness | Setting Time Initial & Final | Sample Pass/Fail | Mode of disposal or action taken if sample fails |
|------------------|------|----------|------------------------------|------------------|--|
| | | | | | |

Form No 10

COMPOSITE CEMENT PACKING STAGE (Daily/Weekly Composite Sample)

| Date of Packing | IR | MgO | Total Sulphur calculated as SO ₃ | Sulphide Sulphur | LOI | Chloride Content | Alkali content @ | Fineness | Soundness (Le-chatelier & Autoclave) | Setting Time Initial & Final | Compressive strength | Drying Shrinkage | Transverse Strength | Sample Pass/Fail | Action taken if sample fails |
|-----------------|----|-----|---|------------------|-----|------------------|------------------|----------|--------------------------------------|------------------------------|----------------------|------------------|---------------------|------------------|------------------------------|
| | | | | | | | | | | | | | | | |

@ Alkali content test may be conducted as and when required by purchaser

Form No 11

CALIBRATION

| Sl. No | Date of calibration | Result of Calibration (Test records indicating details of standard values and observed values for each equipment to be kept in proforma for which various columns be devised; as required) | Name of equipment Action taken if equipment found defective | Sl.No. (If any) & Remarks |
|--------|---------------------|--|--|---------------------------------|
| | | | | |

Note : The above records are to be kept separately for each equipment.

RECORDS TO BE MAINTAINED AS PER TABLE-2 OF SIT (BY BULK PACKING UNIT)

Form No. 12

FORMAT FOR MAINTENANCE OF TEST RECORDS WEIGHMENT CONTROL AT PACKING STAGE
HOURLY CHECK OF MASS OF DRUMS

| Date | Time (Hourly) | Condition of Drums | Net quantity of cement | Record of calibration of weighing scale and Date of calibration. |
|------|---------------|--------------------|------------------------|--|
| | | | | |

Form No. 13

FORMAT FOR MAINTENANCE OF RECORDS FOR THE CONDITIONS OF THE EMPTY DRUMS/BULKERS
FOR PACKING CEMENT

| Date | No. of empty drums/Bulkers checked | No. of empty drums/Bulkers rejected | Reasons/Remarks | Sign of firms inspector |
|------|------------------------------------|-------------------------------------|-----------------|-------------------------|
| | | | | |

Form No. 14

FORMAT FOR MAINTENANCE OF TEST RECORDS WEIGHMENT CONTROL AT PACKING STAGE
HOURLY CHECK OF MASS OF BAGS

| Date | Shift | Time(Hourly) | No of Bags | Net quantity of Bags from Nozzles | Records of calibration/date of calibration of nozzles |
|------|-------|--------------|------------|-----------------------------------|---|
| | | | | | |

Form No. 15

RECEIPT OF CEMENTS

| Date of receipt | Batch No. | Supply received from | Test Certificate No |
|-----------------|-----------|----------------------|---------------------|
| | | | |

Form No. 16
CEMENT DISPATCH DATA FROM PACKING

| Date | Quantity | Passed for Standard Mark | Rejected (if any) | Reasons for not marking/Method of disposal |
|------|----------|--------------------------|-------------------|--|
| | | | | |

Form No 17 & 18
TEST DONE AT FACTORY (At receipt stage and at bulk packing terminal)

| Date | Batch No. | LOI | IR | Sulphide Sulphur | Fineness | Setting Time | Remarks |
|------|-----------|-----|----|------------------|----------|--------------|---------|
| | | | | | | | |

Form No 19 & 20
COMPOSITE CEMENT (PHYSICAL TEST REPORT) (At receipt stage and at bulk packing terminal)

| Date | Batch No. | Test Report | Soundness | | Compressive Strength | | | Remarks |
|------|-----------|-------------|-----------|----|----------------------|--------|---------|---------|
| | | | LC | AC | 3 days | 7 days | 28 days | |
| | | | | | | | | |